

# Work Order ID 60632

Thursday, July 15, 2010 10:30:22 AM



Page 1

Item ID: D3946-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Center Post

Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: H

Date: 10-7-15 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3946

A

100

0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

X/ BB  
10/07/19

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per 051022 POLYCARBONATE  
Temp: 240 F

Time IN:

4:30 PM 10/07/18

Time OUT:

7:00 AM 10/07/19

X/ BB  
10/07/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	THERMOFORMING MACHINE	0.00							
Thermoform	Memo	0.00							
Thermoforming Machine	1-Machine Set-up								
	2-Pre-heat tool								
	3-Thermoform as per Dwg. D3646-1 and Folio FTA 043 using tool DT9483								
	Dwg. Rev. <u>A</u>								
	Folio Rev. <u>B</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Visually inspect for proper formation of each part								
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

(X1) BB  
10/07/19

(X1) BB  
10/07/19

F/A  
10/07/22 (1)

W/O:		WORK ORDER CHANGES						
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**Work Order ID 60632**

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Page 3

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Item Name: Panel, Center Post

Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

0.00

0.00

Trim to Finished Dimensions as per dwg D3946-1

(X) BB  
10/07/19

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Check dimensions to ensure conformity to drawing tolerances.

(X) BB  
10/07/19

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/07/27

(X)

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

**Work Order ID 60632**

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Page 4

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Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg & Stock Location: 150

0.00



Packaging

Memo

0.00

Packaging

10-7-27

S

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/28

10-7-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, July 15, 2010 10:30:26 AM

Page 1

Work Order ID: 60632

Parent Item: D3946-1

Parent Item Name: Panel, Center Post

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC  
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,876.541	3.305	3.478947			



GE PLASTICS LEXAN SHEET



Location

Loc Qty

Loc Code

therm

1876.541

107574

13.72

111973

30.875

112176

101.2267

114459

1730.7193

(X1)

BB

10/07/19

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	40632
<b>Description:</b> Panel, Center Post		<b>Part Number:</b>	D3946-1
<b>Inspection Dwg:</b> D3946	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> BB	<b>Date:</b> 10/07/22
------------------------	-----------------------

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.25	REF	39.375	✓			
1.25	REF	1.375	✓			
3.2	REF	3.4	✓			
0.070	Min	0.074	✓			

<b>Measured by:</b> BB	<b>Date:</b> 10/07/22
<b>Audited by:</b> AA 100722 12	<b>Date:</b>
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	AA

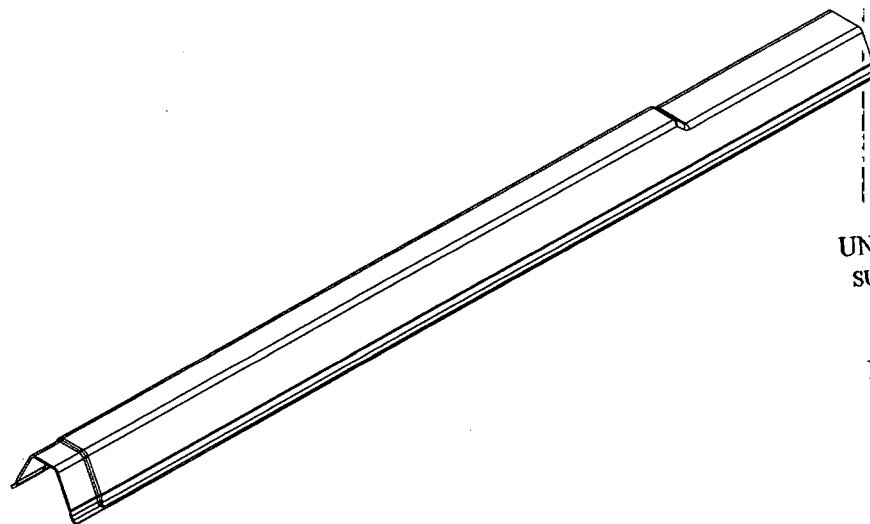
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40632  
BF10-7-15

D3946-1 PANEL, CENTER POST

RELEASED  
09/05/19

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3946-1" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.74 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.070" UNLESS OTHERWISE NOTED

A	NEW ISSUE	PH	09.05.19
REV. A	DESCRIPTION	BY	DATE
DESIGN	<u>PH</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>PH</u>	DRAWING NO.	REV. A
CHECKED	<u>PH</u>	D3946	SHEET 1 OF 2
MFG. APPR.	<u>PH</u>	TITLE	SCALE
APPROVED	<u>PH</u>	PANEL, CENTER POST	NTS
DE APPR.	<u>PH</u>	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
DATE	09.05.19	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

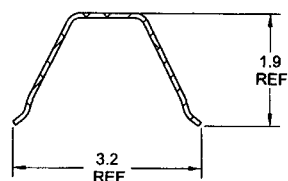
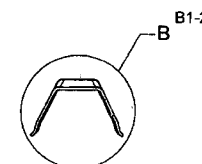
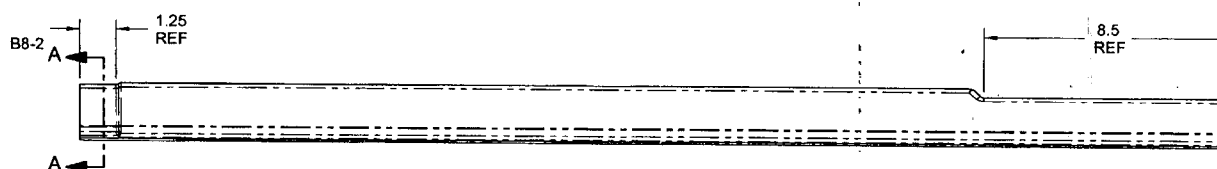
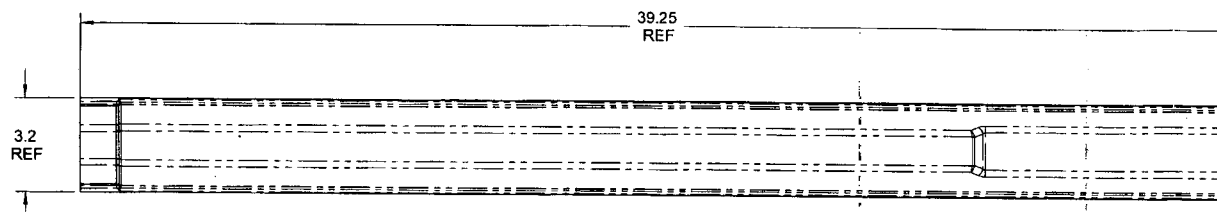
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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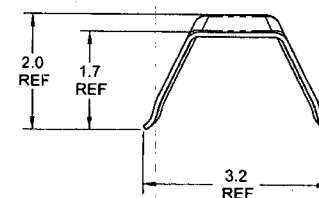
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RELEASED  
2008/11/14



**SECTION A-A**  
SCALE 2X



**DETAIL B**  
SCALE 2X

**D3946-1 PANEL, CENTER POST**

*w/o 40632*

DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	PG	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PG	DRAWING NO. <b>D3946</b>	REV. A
MFG. APPR.	PG	SHEET 2 OF 2	
APPROVED	PG	TITLE	SCALE
DE APPR.	PG	<b>PANEL, CENTER POST</b>	NTS
DATE	09.05.19	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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